

Date: Monday, 03/11/2008 8:58:26 AM
User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE LH (209)
Job Number : 43137	
Estimate Number : 11598	
P.O. Number :	Part Number : D29181
This Issue : 03/11/2008 S.O. No. :	Drawing Number : D2918 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 37421	Material :
Written By : <i>JLM 08.10.03</i>	Due Date : 10/11/2008 Qty: <i>3</i> Um: Each
Checked & Approved By :	
Comment : Est. A 04.07.16 New Issue KJ/JLM	
est B 07.08.07 ECN930 EC verified by: JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6102011	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

6061-T6 8.25x6.5x2.5

Cut blanks: 2.500" x 8.250" x 6.50" grain along 6.50"

Material: 6061-T6/T651 (QQ-A-250/11)

(D6102-011)

Identify as D2918-1

Batch: *B3760X1**B23642 X2**JLM 08/11/05*

③

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program batch number

Machine Step No 1 as per Folio FA441 and visually inspect as per Dwg D2918 & attached Dimension Sheet

Machine Step No 2 as per Folio FA441 and visually inspect as per Dwg D2918 & attached Dimension Sheet

Machine Step No 3 as per Folio FA441 and visually inspect as per Dwg D2918 & attached Dimension Sheet

Deburr

J.F. 08/11/06

③

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per Dwg D2918 & attached dimension sheet

J.F. 08/11/06

③

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE LH (209)

Job Number: 43137

Part Number: D29181

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J-F. 08/11/06

(3)

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JL 08/11/06

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 08/11/07

(3)

7.0

POWDER COATING

POWDER COATING



M109152



(3X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8-00
325 OF
8-30

M-L 08/11/10

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL 08/11/10

(3)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

S7423

P 08/11/10

(3)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/10

Job Completion



MF-08-11-10

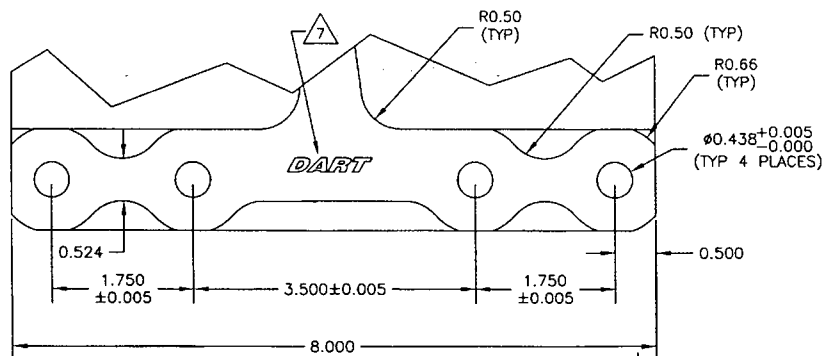
DART AEROSPACE LTD		Work Order:	43137
Description: Saddle LH		Part Number:	D2918-1
Inspection Dwg: D2918 Rev. A1 <i>08.11.10</i>		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2918 Rev. A1 and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.090	0.110		.100"	.100"	.100"			
B	0.175	0.205		.190"	.188"	.188"			
C	0.175	0.217		.195"	.195"	.193"			
D	R0.470	0.530		R.500"	R.500"	R.500"			
E	0.740	0.760		.760"	.760"	.760"			
F	0.277	0.297		.284"	.283"	.281"			
G	3.170	3.230		3.200"	3.200"	3.200"			
H	0.180	0.220		.180"	.180"	.180"			
I	1.599	1.614		1.612"	1.612"	1.612"			
J	0.250	0.270		.263"	.261"	.260"			
K	4.436	4.446		4.441"	4.441"	4.441"			
L	1.498	1.508		1.501"	1.501"	1.501"			
M	1.278	1.288		1.280"	1.280"	1.280"			
N	0.053	0.073		.063"	.063"	.063"			
O	1.103	1.113		1.005"	1.005"	1.005"			
P	1.225	1.235		1.231"	1.231"	1.231"			
Q	0.257	0.262		0.258"	0.258"	0.258"			
R	1.990	2.010		2.000"	1.998"	2.000"			
S	1.385	1.400		1.391"	1.388"	1.391"			
T	0.760	0.765	760	760	.760"	.760"			
U	0.307	0.312		.311"	.311"	.311"			
V	0.615	0.635		.632"	.630"	.631"			
W	0.438	0.443		0.442"	0.442"	0.442"			
X	0.490	0.510		.500"	.502"	.510"			
Y	1.745	1.755		1.752"	1.752"	1.752"			
Z	3.495	3.505		3.503"	3.503"	3.503"			
AA	7.990	8.010		8.000"	8.000"	8.000"			
AB	.023	.023							
AC	.173	.198							
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: J.F.	Audited by: J.L.
Date: 08/11/06	Date: 08/11/06

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	<i>[Signature]</i>



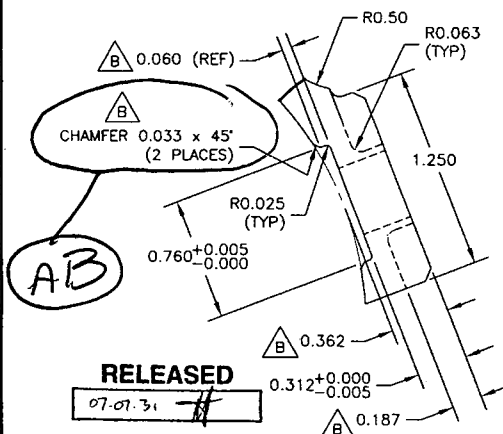
VIEW B-B

D2918-1 LH SADDLE (SHOWN)
D2918-2 RH SADDLE (OPPOSITE)

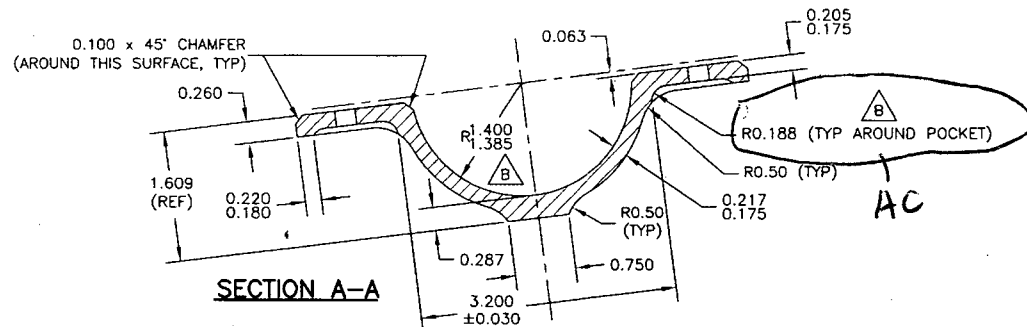
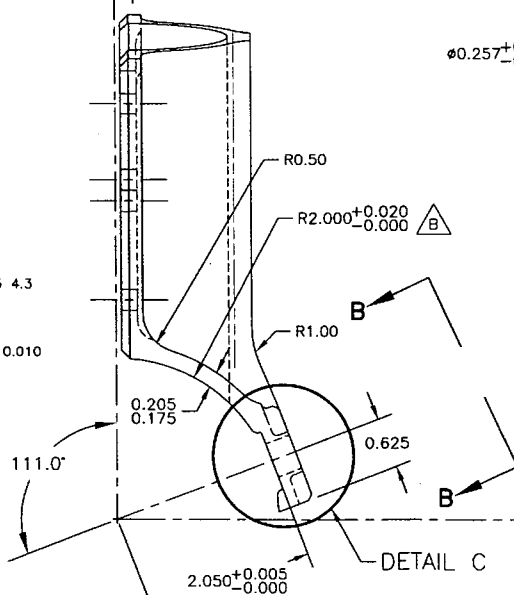
NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T651 PER QQ-A-250/11
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 7) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125

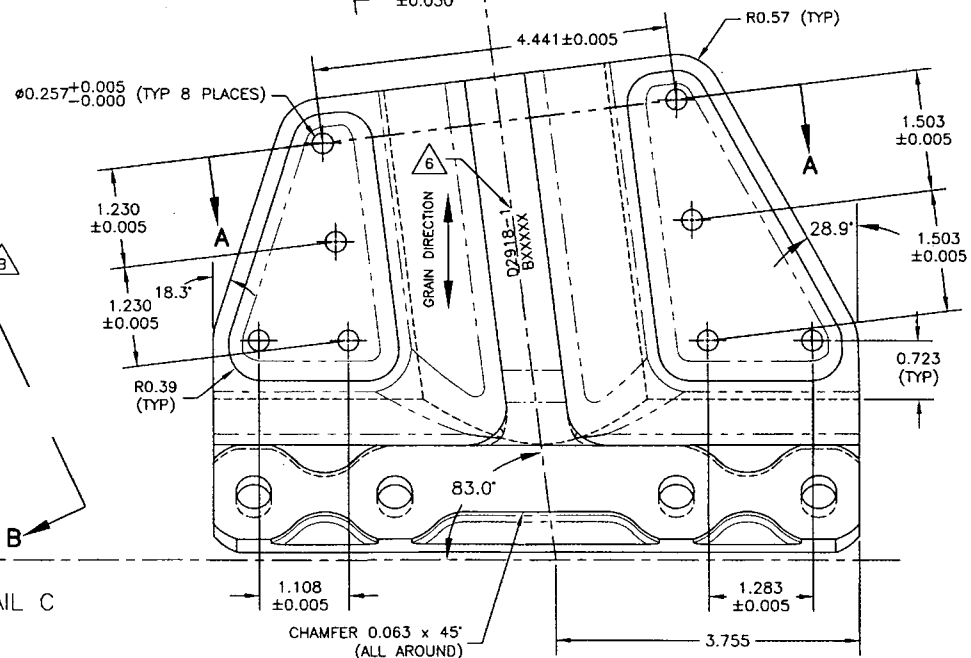
B



DETAIL C
 SCALE 4:3



SECTION A-A



B	07.02.19	ADD 0.362, 0.187, 0.060, CHAMFER; ADD DETAIL C; R0.188 WAS R0.30; ADD TOL TO R2.000; ADD NOTES
A	04.05.31	NEW ISSUE
DESIGN	GP	DRAWN BY
CHECKED	PH	APPROVED
DATE	07.02.19	TITLE
		SADDLE

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DART DART AEROSPACE LTD.
 HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
 D2918
 SHEET 1 OF 1
 SCALE
 2:3